

Date: Monday, 02/03/2009 11:23:33 AM
 User: Julie Dawson

Process Sheet

| | |
|---|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : ARM |
| Job Number : 46161C | |
| Estimate Number : 10145 | |
| P.O. Number : | Part Number : D2037101 |
| This Issue : 02/03/2009 S.O. No. : | Drawing Number : D2037 REV D |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : / / Type : SMALL /MED FAB | Drawing Revision : D |
| Previous Run : 45877A03 | Material : |
| Written By : | Due Date : 20/03/2009 Qty: 4 Um: Each |
| Checked & Approved By : <u>JLD 09.03.02</u> | |
| Comment : Est Rev:A New Issue 05-11-01 JLM Est Rev:B 08-07-29 revD as per dwg DD verified by:EC | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|----------------|--------------------------|
| 1.0 | M304TR0750W049 | 304 RD Tube .750 x .049W |
|-----|----------------|--------------------------|



Comment: Qty.: 4.1118 f(s)/Unit Total : 16.4472 f(s)
 Material: 3/4 O.D. x .049" wall, 304/316 SS Seamless tubing (M304TR0.750W.049)
 Batch: M110113

SS 09/04/07 (4)

| | | |
|-----|----------|----------|
| 2.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|

**Comment:** NC BRAKE

1-Punch as per Dwg D2037. Keep hole distance 45.50" using Jig D2037-101T1

SS 09/04/07 (4)

| | | |
|-----|-------------|-------------------------------|
| 3.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 |
|-----|-------------|-------------------------------|

**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill Ø0.323" holes in D2037-101 tube as per Dwg D2037

2-Flatten ends of D2037-101 tube as required using DT8545

3-Deburr as required

M-H 09/04/14

| | | |
|-----|-----|------------------------------|
| 4.0 | QC5 | INSPECT WORK TO CURRENT STEP |
|-----|-----|------------------------------|

**Comment:** INSPECT WORK TO CURRENT STEP

SS 09/04/14 (4)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Monday, 02/03/2009 11:23:33 AM
Usér: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ARM

Job Number: 46161C

Part Number: D2037101

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: misc

CPL 09.04.14

(X4)

6.0

QC21

FINAL INSPECTION/W/O RELEASE



09/04/14 *MF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-04-14

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

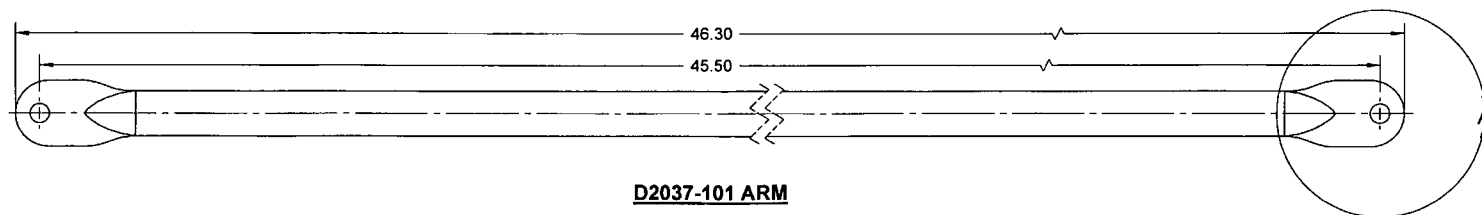
D2037-101 ARM

RELEASED
08.07.07

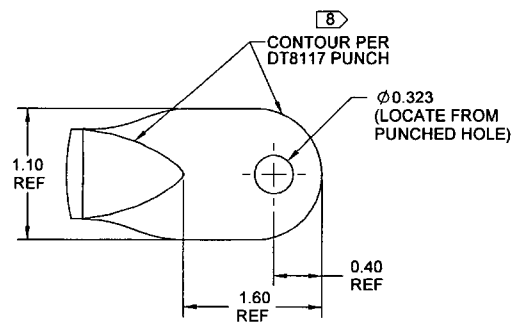
SHOP COPY
RETURN TO
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WITHOUT NOTICE
WORK ORDER
NO. 101-101

- NOTES:**
- 1) MATERIAL: AISI 304/316, STAINLESS STEEL ROUND TUBE, $\phi 0.750 \times 0.049$ WALL
REF. DART SPEC M304TR0.750W.049
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.50 lbs
 - 8) FOR FURTHER INFO SEE DRAWING D2638.

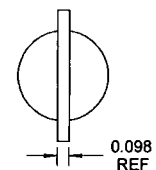
| D | INCORPORATED C1, C2 & C3. REDRAWN TO SOLIDWORKS FORMAT WITH CURRENT STANDARDS. ORIGINAL "SQUARE END" CONFIGURATION DELETED (SEE REV. C FOR FURTHER DETAILS). SHEET 2 DETAIL A NOW INDICATED AS 2 PL. REASON FOR CHANGE: QC/PRODUCTION REQUEST. | AJS | 08.05.08 |
|------------|--|--|--------------|
| C | REDRAWN, 0.386 WAS 0.375. | RF | 99.06.07 |
| B | -103 DELETED | JB | 93.04.20 |
| A | NEW ISSUE | JB | 91.10.22 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D2037 | SHEET 1 OF 2 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | ARM | NTS |
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D2037-101 ARM



DETAIL A
SCALE 2X
2 PL



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08.07.07

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WORK ORDER
NO. 408101C

| | | | |
|------------|----------|---|--------------|
| DESIGN | JB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. D |
| MFG. APPR. | | D2037 | SHEET 2 OF 2 |
| APPROVED | | TITLE | SCALE |
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